

Work Order ID 115326

March-25-14 9:58:23 AM

115326

Ship monday

Page 1

Item ID: D350-636-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/08/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 13-03-25

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750-042

G

D3492

C

100

Document Control

0.00

100

DOCUMENT CONTROL

0.00

DC

Memo

Doc. Control -USB or Paperwork

record fwd angle: 89.8°

BE14-04-02

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

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Item ID: D350-636-012

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14 Start Qty: 1.00 *1*

Required Date: 4/08/14 Req'd Qty: 1.00 *1*

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

110

Skidtubes

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8- Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10- Open up holes of Detail J to 0.297" (total of 2 holes per side)

8E14-04-02

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Item ID: D350-636-012

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/08/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004A/R Aluminum Rod batch: *M128385*

12-Grind welds flush as per Dwg D2750

BE14-04-02

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

① 14-04-03 **DAS**
9
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

① 14-04-03 **DAS**
9
9-89

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Item ID: D350-636-012

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Start Qty: 1.00

1

Required Date: 4/08/14

Req'd Qty: 1.00

1

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

QC: _____

Date: _____

Tooling: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
Description

140

Chemical Conversion Coat per QSI005 4.1

140

HandFinish

Memo

Hand Finishing

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

1 7-14-13

150

QC7-Inspect Chemical Conversion Coat

150

QC

Memo

Quality Control

0.00

0.00

DD 14-4-3

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Item ID: D350-636-012

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14 Start Qty: 1.00 *1*

Required Date: 4/08/14 Req'd Qty: 1.00 *1*

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

160

Skidtubes

Skidtubes

Skidtubes

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI015

A/R Sikaflex-291 batch: 128026
exp. date: 11-10-09

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod batch: 1128385

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

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Item ID: D350-636-012

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Start Date: 3/25/14

Start Qty: 1.00

1

Required Date: 4/08/14

Req'd Qty: 1.00

1

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

QC: _____

Date: _____

Tooling: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

> DCL 14-4-8

① 14-04-08

DAS
9
9-89

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

VERIFY C'BOARD IS GOOD

① 14-04-08

DAS
9
9-89

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Item ID: D350-636-012**Revision ID:****Item Name:** Skidtube RH Aerazur / Apical Cylindrical Compat.**Start Date:** 3/25/14 **Start Qty:** 1.00 ***1*****Required Date:** 4/08/14 **Req'd Qty:** 1.00 ***1*****Reference:****Accept*****N900040100*****Setup Start *NS1*****Stop *NS2*****Cust Item ID:****Customer:****Approvals:** **Process Plan:** **Date:****QC:** **Date:****Tooling:** **Date:****SPC (Y/N):** **Date:****Run Start *NR1*****Stop *NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200

0.00

200

SprayPaint

Memo

0.00

Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2
PRIMER PRC DESOTO 515X349 BATCH:2- PAINT WHITE AS PER DWG AND QSI 005 4.2
PAINT BATCH:

210

0.00

210

QC

QC14- Inspect Spray Paint

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

N/A see w/o 116351

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Item ID: D350-636-012
 Revision ID:
 Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.
 Start Date: 3/25/14 Start Qty: 1.00 *1*
 Required Date: 4/08/14 Req'd Qty: 1.00 *1*
 Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____
 QC: _____ Date: _____

Tooling: _____ Date: _____
 SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: _____								
	EXP DATE: _____								
	4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: _____								
	5-Coat all exposed fasteners with "LPS Procyon" batch: _____								
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									

SPC
14/4/14

134 / 40 w/05/14

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Item ID: D350-636-012

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14 Start Qty: 1.00 ***1***

Required Date: 4/08/14 Req'd Qty: 1.00 ***1***

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

1X

DAS
28
9-89

APR 11 2014

11
9-89

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

DAS
31
9-89

14-04-14

1

*pull on
into 116351
unpainted
un-assembled*

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

DAS
06
9-89

APR 14 2014

[Handwritten signature]

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Item ID: D350-636-012**Revision ID:****Item Name:** Skidtube RH Aerazur / Apical Cylindrical Compat.**Start Date:** 3/25/14 **Start Qty:** 1.00 ***1*****Required Date:** 4/08/14 **Req'd Qty:** 1.00 ***1*****Reference:****Accept*****N900040100*****Setup Start *NS1*****Stop *NS2*****Cust Item ID:****Customer:****Approvals:** **Process Plan:** **Date:****QC:** **Date:****Tooling:** **Date:****SPC (Y/N):** **Date:****Run Start *NR1*****Stop *NR2*****Sequence ID/
Work Center ID****Operation
Description**

280

QC21- Final Inspection - Work Order Release

280

QC

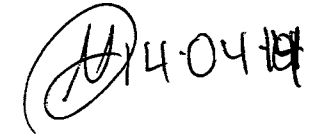
Memo

Quality Control

**Set Up/
Run Hours**

0.00

0.00

**Tool ID Tool # Plan
Code****Accept Reject Reject Insp.
Qty Qty Number Stamp**

Picklist Print

March-25-14 9:58:27 AM

Page 1

Work Order ID: 115326

115326

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I02.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT

Manufactured No

110

Each

6.0000

1

1

D2600-3-BFNT

Extrusion Bent

BE14-04-02

B112976 x1

Location

Loc Qty

Loc Code

LG

6

111091

5

111606

1

D2744

Manufactured No

110

Each

10.0000

1

1

D2744

Cap

BE14-04-02

Location

Loc Qty

Loc Code

LG001

10

100398

10

1

Picklist Print

March-25-14 9:58:27 AM

Page 2

Work Order ID: 115326

115326

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

28.0000

1

1

D2739

350 I Beam

Location

Loc Qty

Loc Code

LG

21

110835

1

111094

9

111609

1

113252

10

LG002

7

112596

7

D2743

Manufactured No

160

Each

247.0000

8

8

D2743

Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

246

111570

125

112729

121

LG001

1

109799

1

D3490-3

Manufactured No

160

Each

88.0000

4

4

D3490-3

Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

88

112736

88

March-25-14 9:58:27 AM

Shop Packet Print

Page 2

DGL 14-4-3

BE1404-07

BE1404-07

8

4

Picklist Print

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Page 3

Work Order ID: 115326

115326

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No

160 Each 121.0000

D3490-1

Cross Bolt Spacer

**

BE 1404-07

Location

Loc Qty

Loc Code

LG

37

(112737)

37

LG001

84

109932

84

D3631-1 Manufactured No

230 Each 176.0000

D3631-1

Washer

**

DAS
28
9-89

APR 11 2014

Location

Loc Qty

Loc Code

FP001

176

110258

16

111019

60

113164

100

D3791-1 Manufactured No

230 Each 22.0000

D3791-1

Wearpad

**

DAS
28
9-89

Location

Loc Qty

Loc Code

FP002

22

110982

19

112413

3

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Shop Packet Print

Page 3

Picklist Print

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Work Order ID: 115326

115326

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

21.0000

1 1

DAS
28
9-89

APR 11 2014

D3793-3

Wearplate Aft

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001

1

104212

1

FP002

20

110887

12

113035

8

230

Each

326.0000

4 4

DAS
28
9-89

MS21043-6

Purchased No

MS21043-6

NUT

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

56

m127255

56

ST509

250

m127813

250

230

Each

27.0000

1 1

DAS
28
9-89

D3794-1

Manufactured No

D3794-1

Gasket Fwd

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001

27

109207

1

111574

13

112521

2

113203

11

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Shop Packet Print

Page 4

Picklist Print

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Page 5

Work Order ID: 115326

115326

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

303.0000

8

8

NAS1611-010

O-RING

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001

303

m126988

3

m127813

4

m128375

288

m128388

8

**

DAS
28
9-89

APR 11 2014

D2741

Manufactured

No

250

Each

17.0000

1

1

D2741

Blade

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

11

100664

5

85480

1

98323

5

ST466

6

107206

2

110710

4

**

DAS
28
9-89

NAS1515H3L

Purchased

No

230

Each

295.0000

4

4

NAS1515H3L

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

36

102472

36

ST297

259

m127831

259

**

DAS
28
9-89

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Picklist Print

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D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Kit

Purchased

No

230

Each

344.0000

8

NAS1611-013

O-RING

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001

344

m128375

344

230

Each

395.0000

8X

AN3C6A

Purchased

No

AN3C6A

Bolt

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

10

122416

10

ST351

42

m128224

42

ST513

343

m125709

343

230

Each

315.0000

4X

NAS1149C0832R

Purchased

No

NAS1149C0832R

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

ST292

315

122441

48

m114915

117

m125807

150

xl

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Picklist Print

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Work Order ID: 115326

115326

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

17.0000

1 1
**

DAS
28
9-89

APR 11 2014

D3536-25

Gasket Center

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

11

110652

1

111417

9

113008

1

D3794-3

Manufactured No

230

Each

5.0000

1 1
**

DAS
28
9-89

D3794-3

Gasket Aft

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001

5

113060

5

230

Each

851.0000

34 34
**

DAS
28
9-89

AN3C5A

Purchased No

AN3C5A

Bolt

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

5

122800

5

ST350

846

M128057

846

34x

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Shop Packet Print

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

74.0000

3 3

DAS
28
9-89

APR 11 2014

D3537-1

Wearpad

kt

DAS
31
9-89

Location

Loc Qty

Loc Code

FG	18
79833	8
88562	10
FP001	56
113839	1
114585	55

115172

D3535-25

Manufactured No

230

Each

25.0000

1 1

DAS
28
9-89

D3535-25

Wearplate Center

kt

DAS
31
9-89

Location

Loc Qty

Loc Code

FG	2
95077	2
FP002	23
110193	1
110744	1
112385	5
113120	16

D3492-3

Manufactured No

230

Each

172.0000

8 8

DAS
28
9-89

D3492-3

Plug

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001	172
104853	24
107331	1
111553	47
112739	100

8X

March-25-14 9:58:27 AM

Shop Packet Print

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Page 9

Work Order ID: 115326

115326

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

10,470.00

38

38

NAS1149C0332R

WASHER

DAS
31
9-89

**

DAS
28
9-89

APR 11 2014

Location

Loc Qty

Loc Code

GA

1033

128591

125654

1033

ST292

5000

m128591

5000

st510

4437

m126319

61

m127306

2500

m127410

1850

m127831

26

230

Each

5.0000

1

1

D3488-042

Manufactured

No

D3488-042

Blade Fitting RH

DAS
31
9-89

**

Location

Loc Qty

Loc Code

FP001

5

B113592

106658

3

98887

2

230

Each

726.0000

38

38

ALS4-1032-225

AELS8-1032-225

Purchased

No

ALS4-1032-225

Rivnut

**

Location

Loc Qty

Loc Code

FG

30

M128619

X36

M127028

30

ST280

662

M127028

10

M128179

652

st555

34

M127092

34

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Work Order ID: 115326

115326

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3492-1 Manufactured No

230 Each 176.0000

D3492-1

Plug

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001

176

111578

14

112738

162

230 Each

8.0000

D3793-1 Manufactured No

D3793-1

Wearplate Fwd

DAS
31
9-89

Location

Loc Qty

Loc Code

FP002

8

110924

8

230 Each

80.0000

AN8C35A Purchased No

AN8C35A

Bolt

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

4

121275

4

FP001

76

m126293

29

m127061

1

m127823

46

230 Each

31.0000

MS21083C8 Purchased No

MS21083C8

Nut

DAS
31
9-89

Location

Loc Qty

Loc Code

ST319

31

m127255

5

m128119

26

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Picklist Print

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Page 11

Work Order ID: 115326

115326

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

274.0000

8 8

D2745

Bushing

DAS
31
9-89

Location

Loc Qty

Loc Code

ST017

274

107336

4

110526

4

111554

124

113176

62

114874

80

**

DAS
28
9-89

APR 11 2014

AN6C44A

Purchased No

230

Each

82.0000

AN6C44A

Bolt

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

2

103964

2

ST341

80

m128319

80

**

DAS
28
9-89

D3532-1

Manufactured No

250

Each

30.0000

D3532-1

Spacer

DAS
31
9-89

Location

Loc Qty

Loc Code

ST054

30

109803

18

113225

12

**

DAS
28
9-89

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Picklist Print

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Page 12

Work Order ID: 115326

115326

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased No

250 Each

31.0000

MS21083C8

Nut

DAS
31
9-89

Location

Loc Qty

Loc Code

ST319

31

m127255

5

m128119

26

250 Each

905.0000

NAS1149D0863J

Purchased No

NAS1149D0863J

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001

2

118078

2

ST293

103

125484

103

ST510a

800

125268

600

125635

200

250 Each

249.0000

D3493-1

Manufactured No

D3493-1

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST051

239

109105

159

112741

80

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

DAS
28
9-89

APR 11 2014

DAS
28
9-89

DAS
28
9-89

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Page 12

Picklist Print

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Page 13

Work Order ID: 115326

115326

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

80.0000

2 2

AN8C21A

Bolt

DAS
31
9-89

(SAC #2)

**

DAS
28
9-89

APR 11 2014

Location

Loc Qty

Loc Code

ST

2

123966

2

ST341

2

m127061

2

ST342

26

m128319

26

ST508

50

m127823

50

2X

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

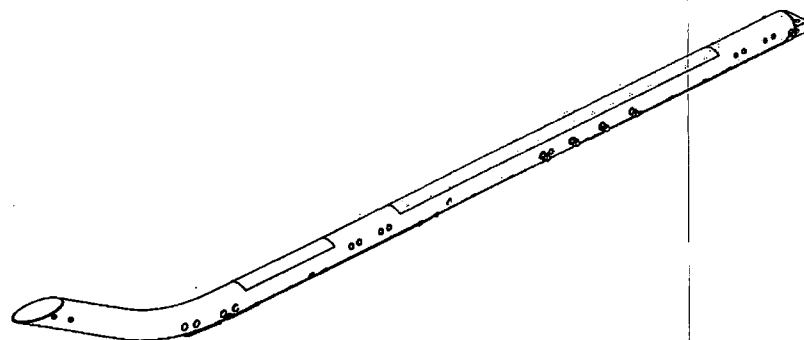
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
 FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

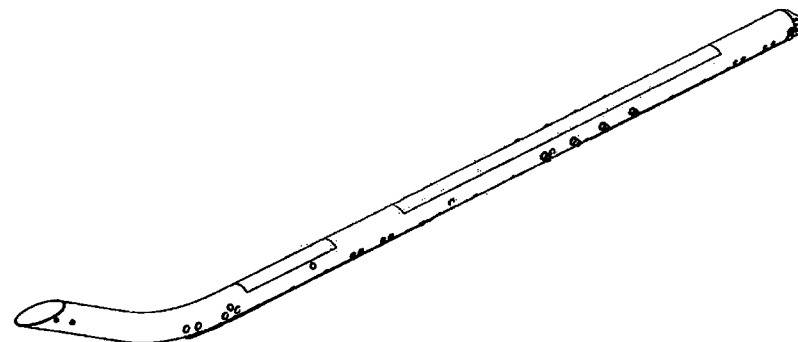
115326 MCT
14-03-25

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2013-08-13
ND

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1, -4/-5/-6/-7); UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN	B		
CHECKED	g		
MFG. APPR.	g		
APPROVED	g		
DE APPR.	g		
DATE	13.07.11		
DART AEROSPACE USA, INC.			
KENT, WA			
DESIGN NO.	D2750	REV. G	
TITLE	350 SKIDTUBE ASSEMBLY	SHEET 1 OF 11	
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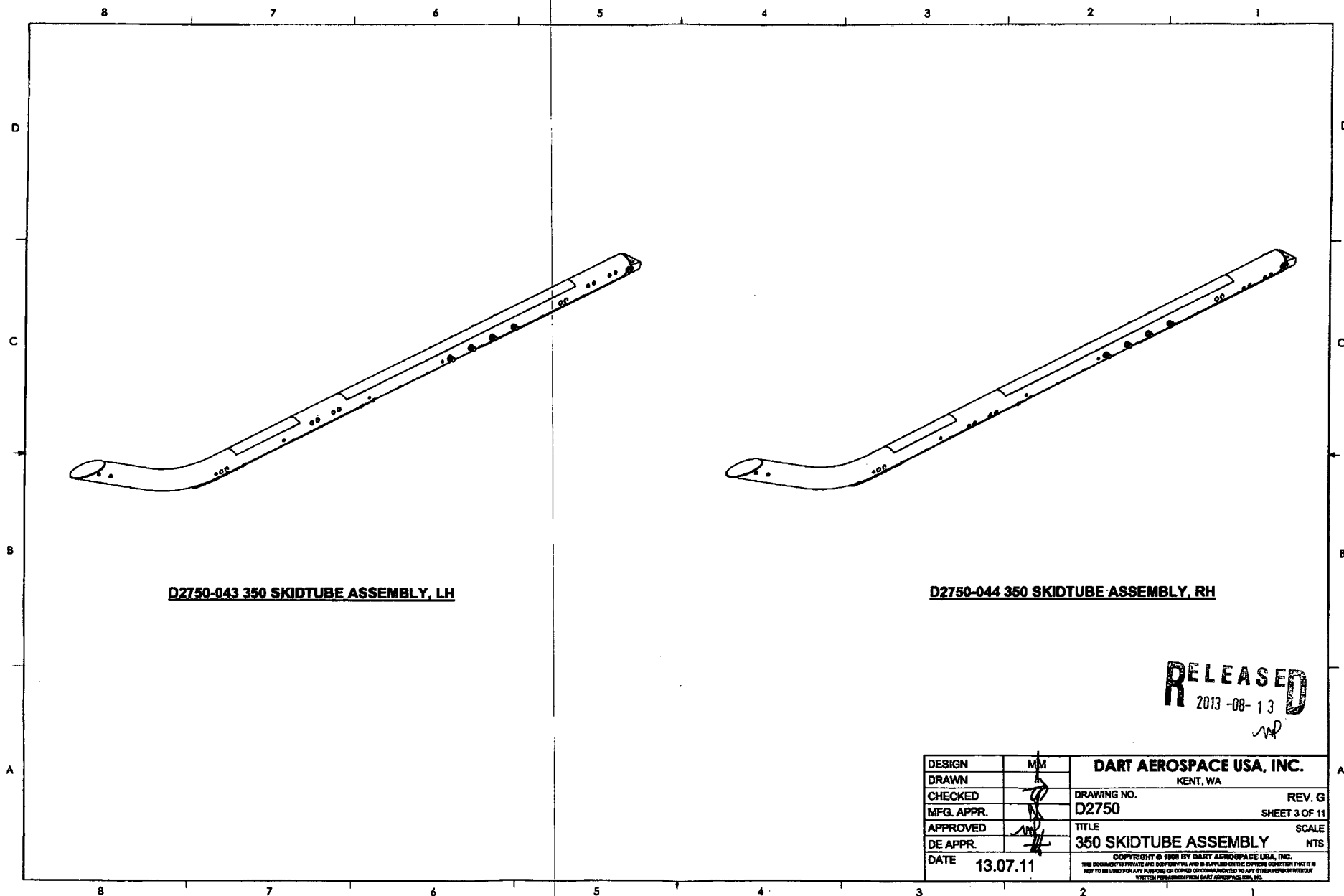
D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13
MD

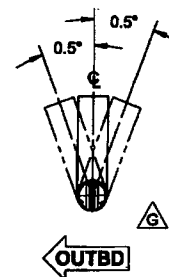
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DRAWN		KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



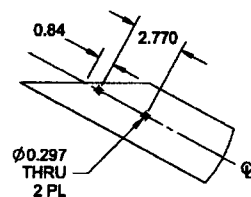
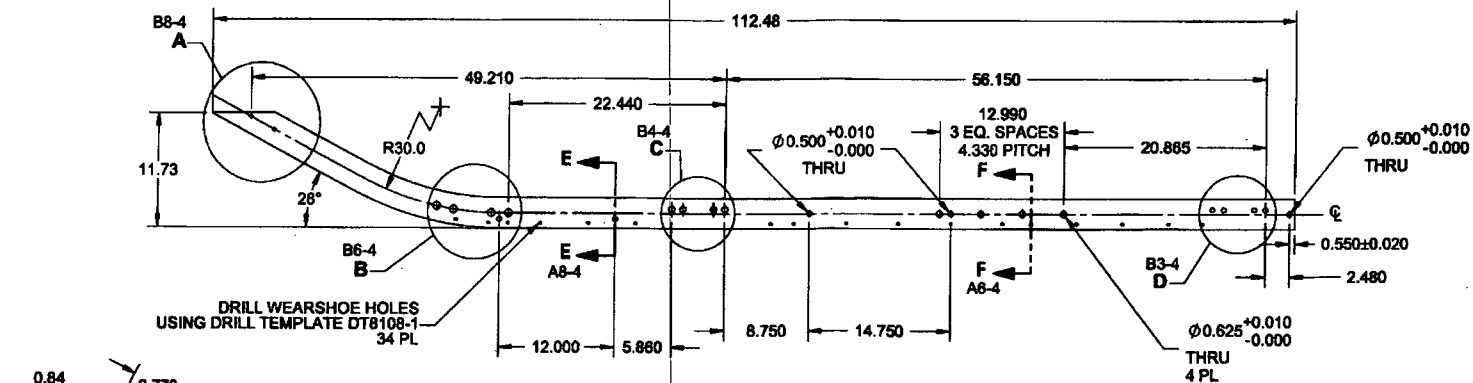
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2013-08-13
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

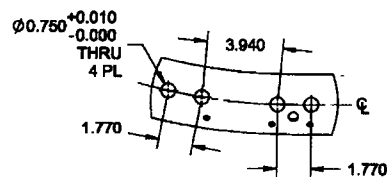
D2750-1 LH SKIDTUBE



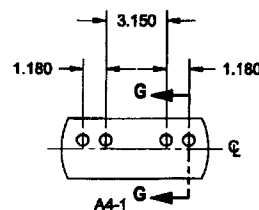
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



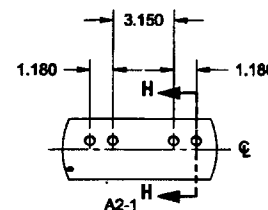
DETAIL A
SCALE 2X



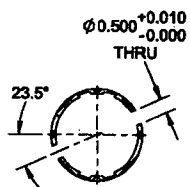
DETAIL B
SCALE 2X



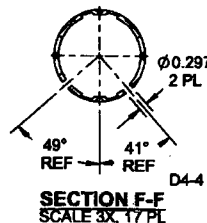
DETAIL C
SCALE 2X



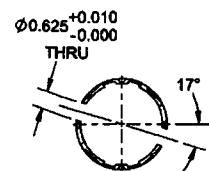
DETAIL D
SCALE 2X



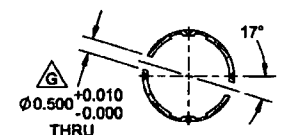
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



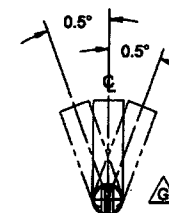
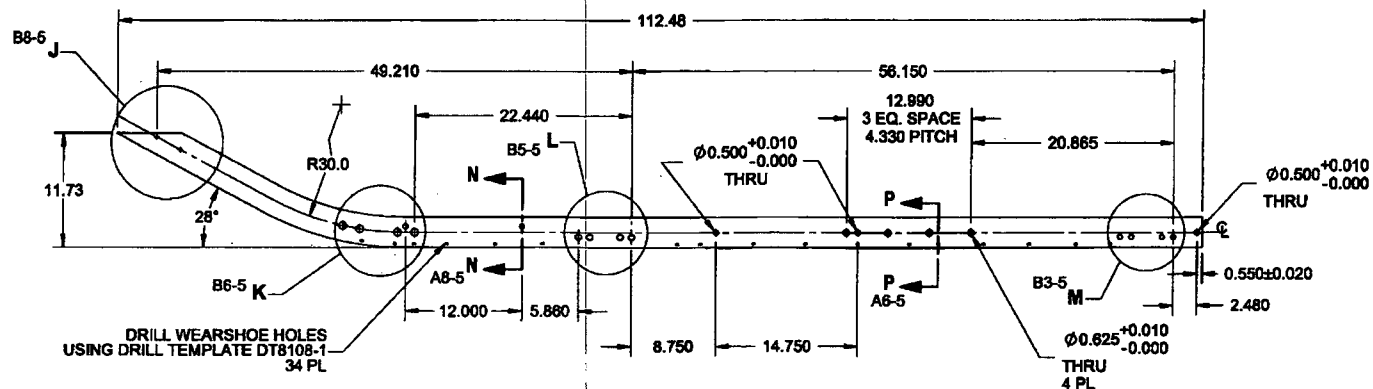
SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE RELEASED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

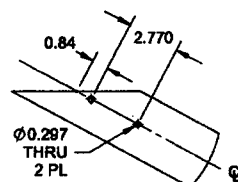
RELEASED
2013-08-13



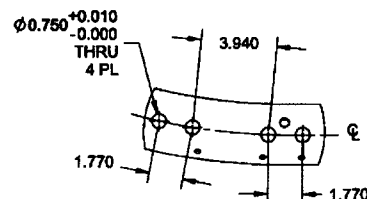
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

OUTBD

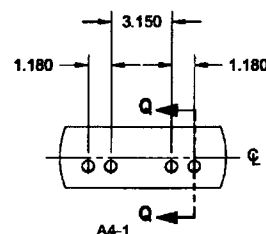
D2750-2 RH SKIDTUBE



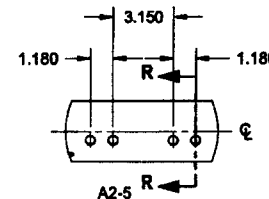
DETAIL J
SCALE 2X



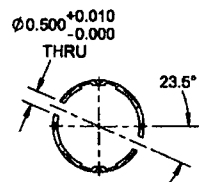
DETAIL K
SCALE 2X



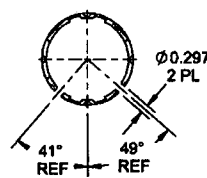
DETAIL I
SCALE 2X



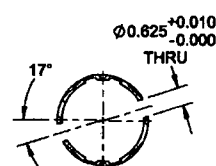
DETAIL M
SCALE 2X



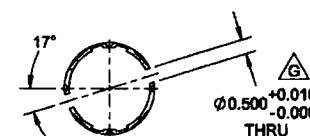
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

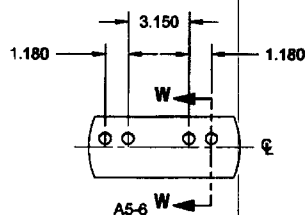
RELEASED
2013-08-13

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DRAWN		KENT, WA
CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. G
APPROVED		SHEET 5 OF 11
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
DATE	13.07.11	SCALE NTS

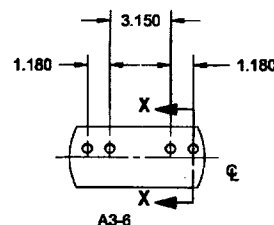
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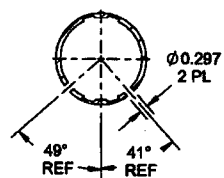
DETAIL S
SCALE 2X



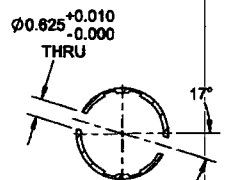
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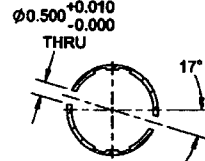
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SCALE 2X








SECTION V-V C4-8
SCALE 3X, 17 PL

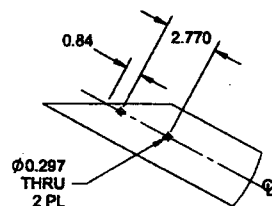
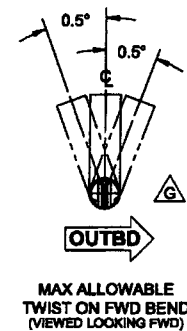
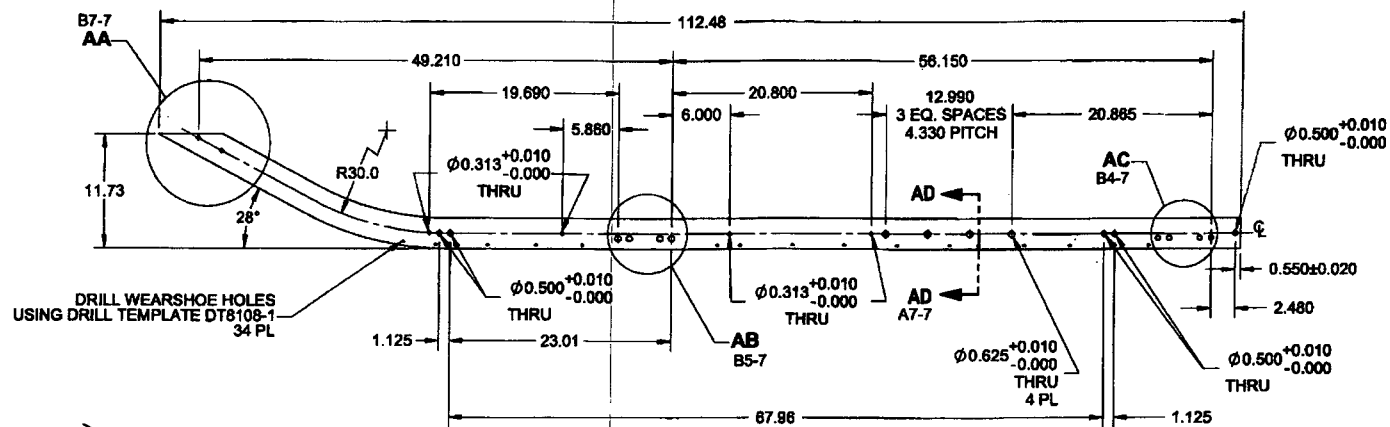


SECTION W-W
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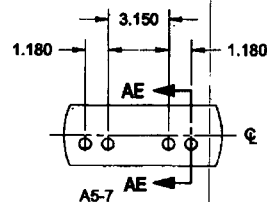


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SCALE 3X, 4 PL

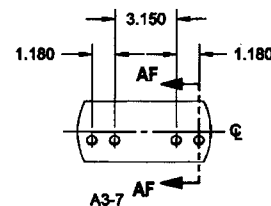
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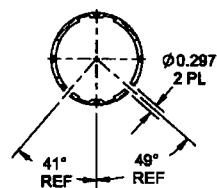
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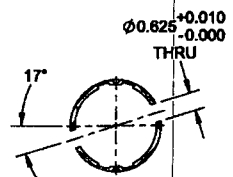
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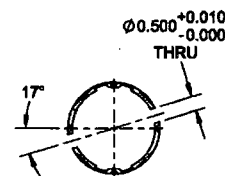
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SECTION AD-AD
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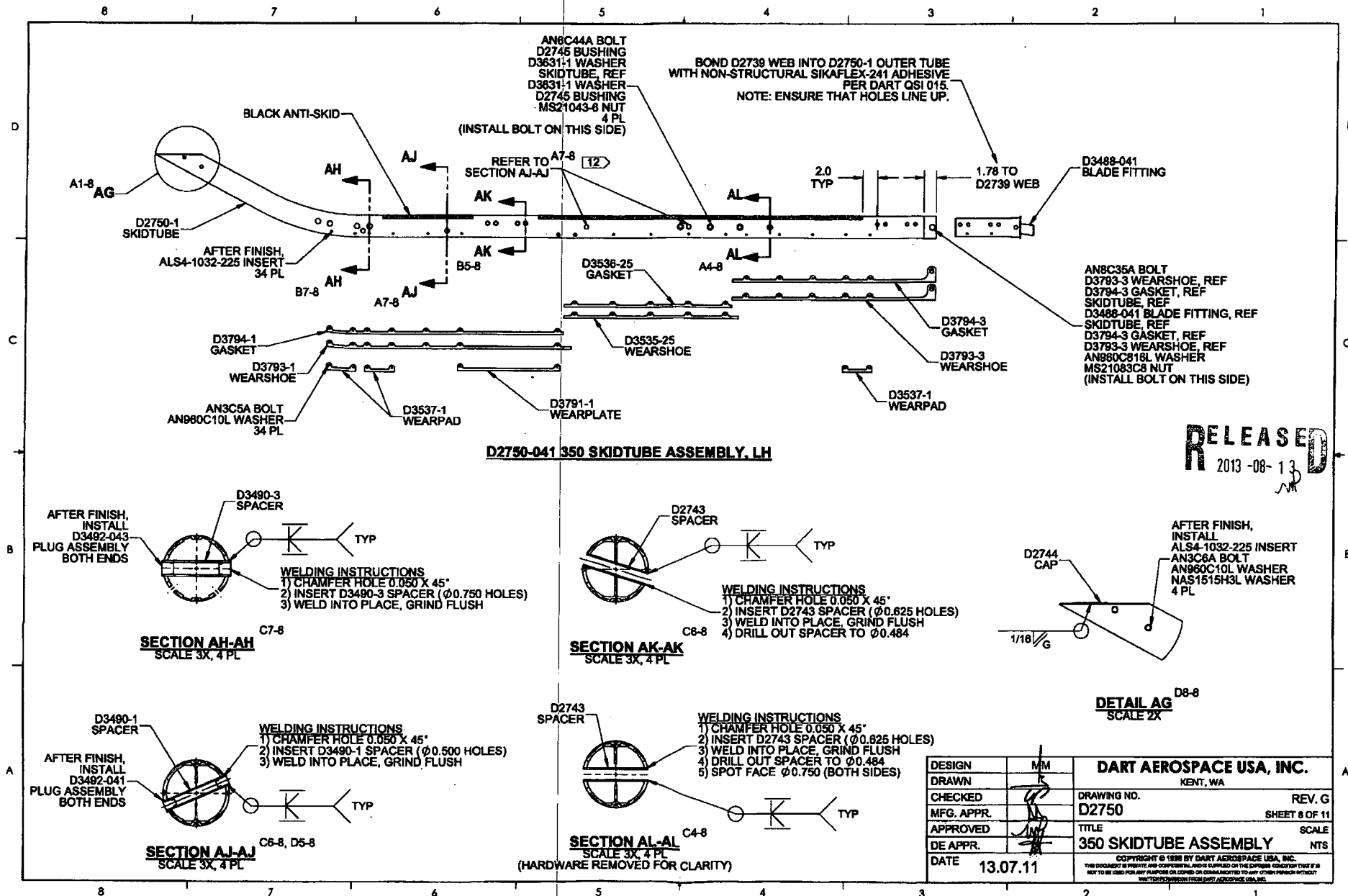
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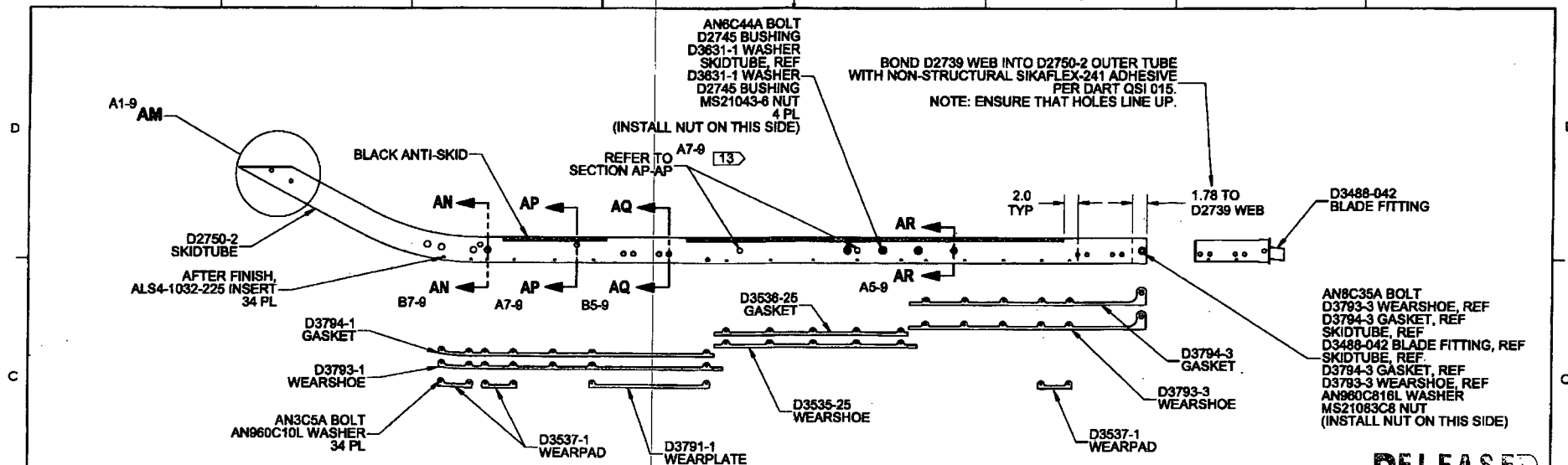
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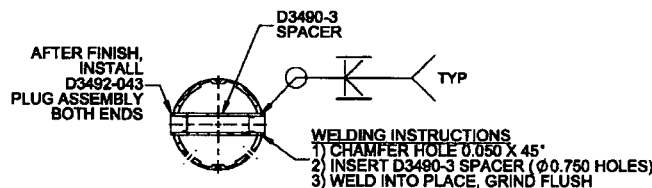


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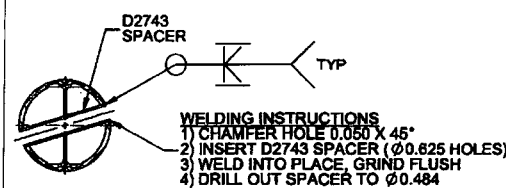


D2750-042 350 SKIDTUBE ASSEMBLY, RH

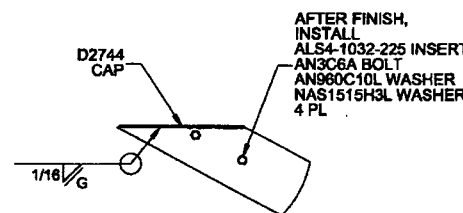
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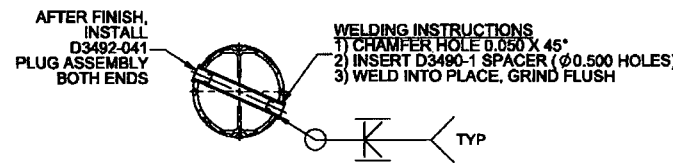
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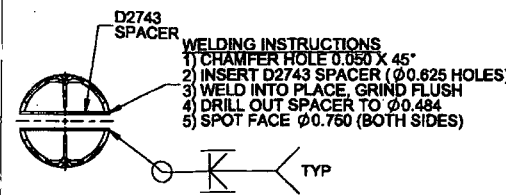
SECTION AQ-AQ
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DETAIL AM
SCALE 2X



SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
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8 7 6 5 4 3 2 1

